

Work Order ID 164858

Thursday, August 03, 2017 11:41:34 AM

164858

Ship Aug 14th

Page 1

Item ID: D3879-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Baggage Protector-Wall

Start Date: 8/4/2017 Start Qty: 2.00

2

Cust Item ID:

Required Date: 8/10/2017 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

DAS
21

Date: AUG 03 2017

Tooling:

Date:

Run Start ***NR1***

QC:

9-89

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

d3879

rev b

100

0.00

100

Waterjet

Memo

0.18

FLOW CNC Waterjet

1-Cut as per Dwg D3879

Dwg Rev: BProg Rev: B

2- Deburr if necessary

②

17/08/10

DAS
40
9-89

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.02

Quality Control

②

17/08/10

DAS
40
9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER : ☐									

Work Order ID 164858

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164858

Page 2

Item ID: D3879-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Baggage Protector-Wall
Start Date: 8/4/2017 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 8/10/2017 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.04				2			DAS 38 9-89 AUG 11 2017
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: <u>PKG</u> Memo	0.00 0.02				2			AUG 14 2017 DAS 6 9-89
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.20							DAS 21 9-89 AUG 16 2017 DAS 21 9-89 AUG 14 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Misidentified ☐	Past Due ☐																																																														

Picklist Print

Thursday, August 03, 2017 11:41:37 AM

Page 1

Work Order ID: 164858

164858

Parent Item: D3879-1

D3879-1

Parent Item Name: Baggage Protector-Wall

Start Date: 8/4/2017

Required Date: 8/10/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.125-F60029-04		Purchased	No			100	sf	3,518.940	7	16.47059			
MI FXS 125-F60029-04									**			17/08/10	DAS 40
GE PLASTICS LEXAN SHEET (DARK GREY)													9-89

Location

Loc Qty

Loc Code

mat

1184

m137737

1184

MAT018

2334.94

m137737

2334.94

16.5

DQA: _____ Date: _____



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DART AEROSPACE LTD		Work Order: 164858
Description: Cargo Wall Protector		Part Number: D3879-1
Inspection Dwg: D3879	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3.72	+/-0.030	3.73	1		VDC-2	
3.12	+/-0.030	3.11	1		T90	
2.38	+/-0.030	2.37	1			
47.45	+/-0.030	47.45	1			
47.89	+/-0.010	47.89	1			
41.97	+/-0.030	41.95	1			
21.00	+/-0.030	21.01	1			
5.50	+/-0.030	5.52	1			
10.00	+/-0.030	10.01	1			
8.47	+/-0.030	8.48	1			
13.50	+/-0.030	13.50	1			
13.38	+/-0.030	13.39	1			
0.125	+/-0.010	0.125	1			

Measured by: DAS 40	Audited by: DAS 38	Prototype Approval: N/A		
Date: 17/08/16	Date: AUG 11 2017	Date: N/A		
Rev	Date	Change	Revised by	Approved
A	09.10.16	New Issue	KJ	

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		OTHER : ☐							